

Fig. 1

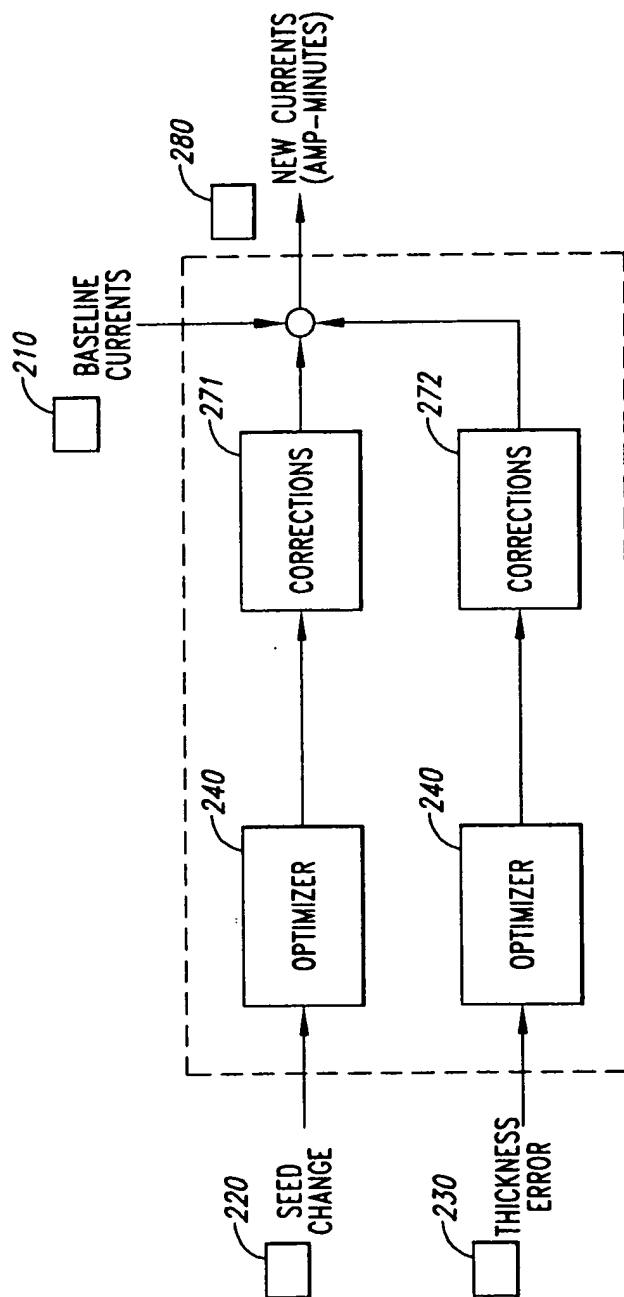


Fig. 2

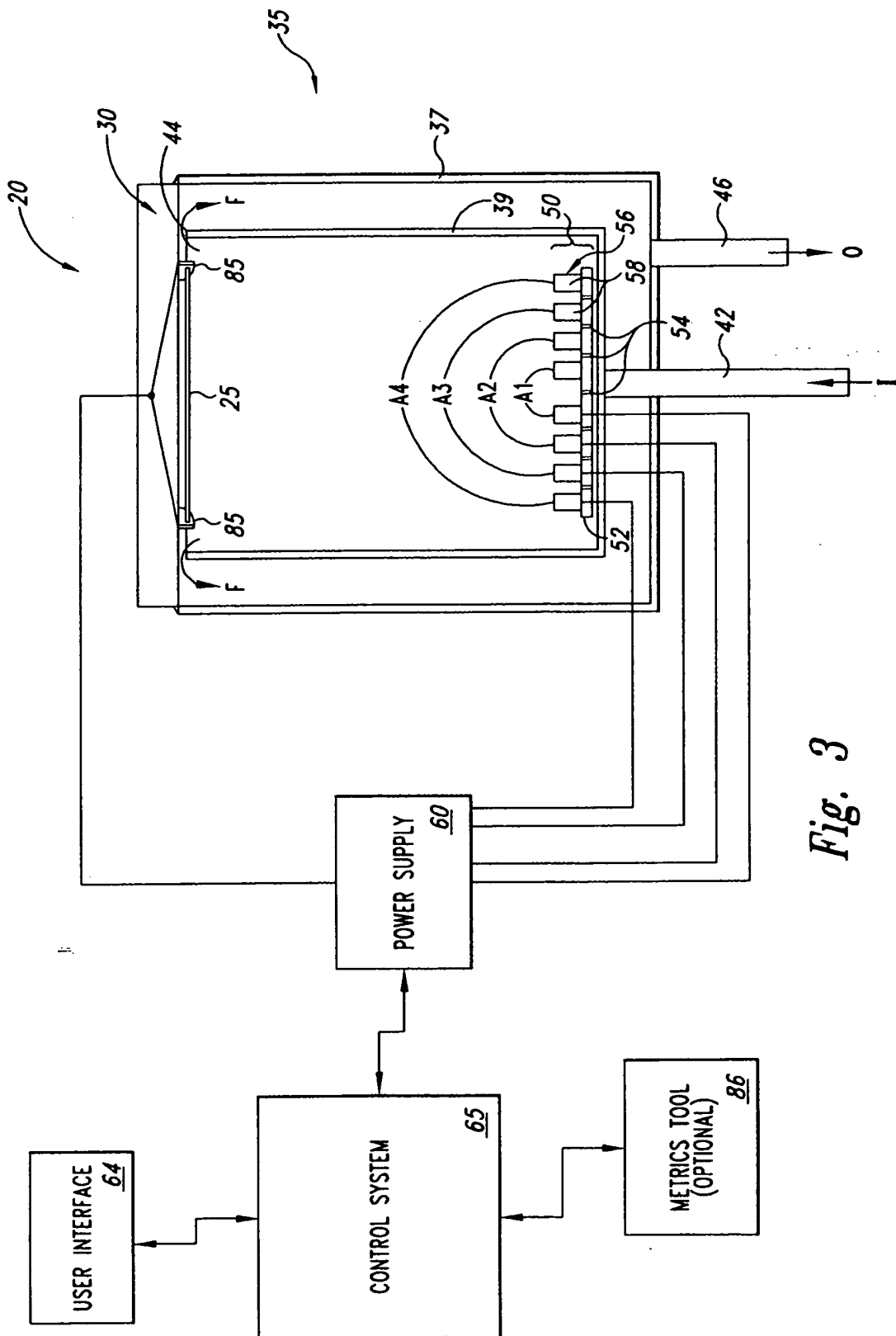
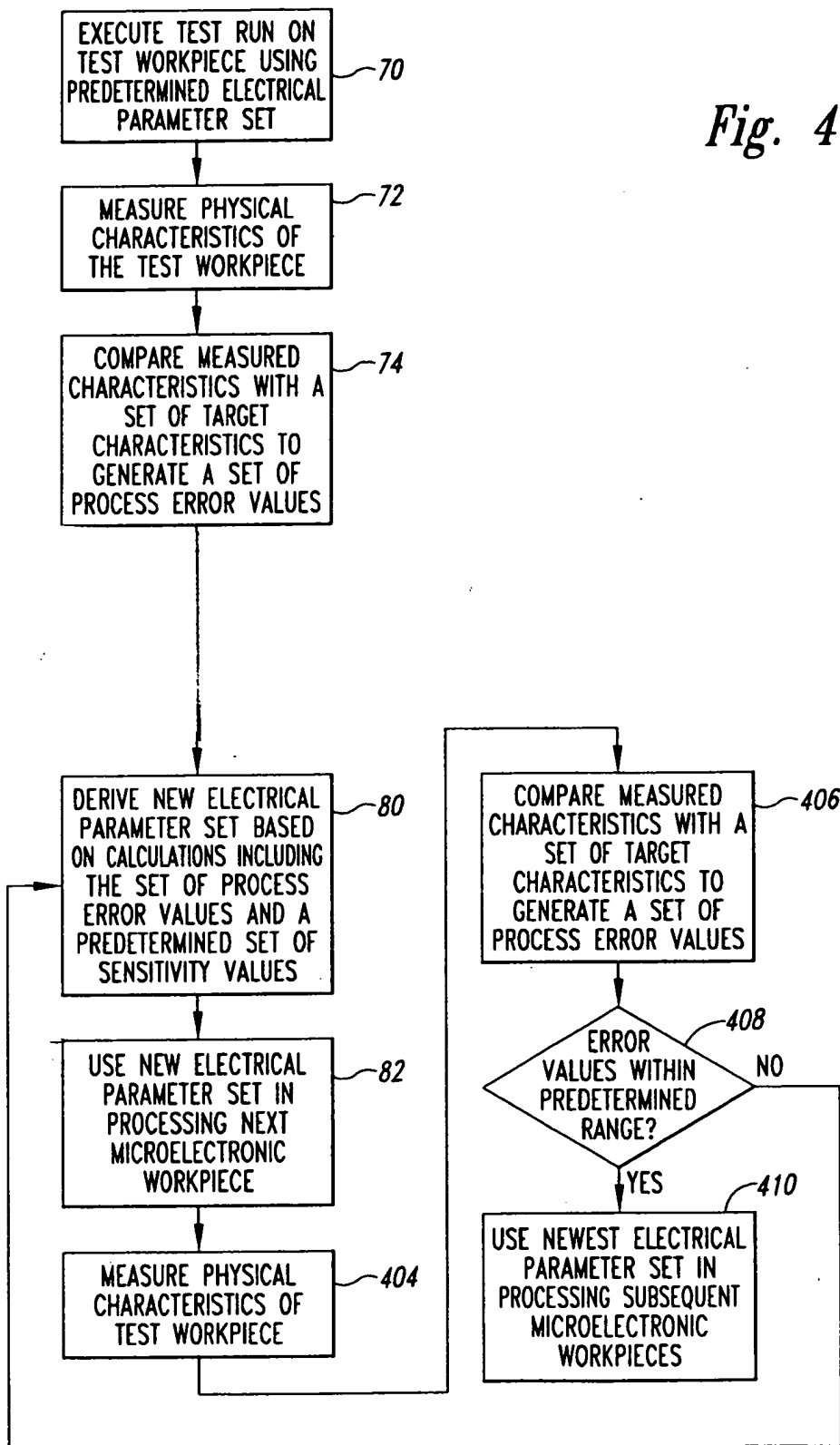


Fig. 4



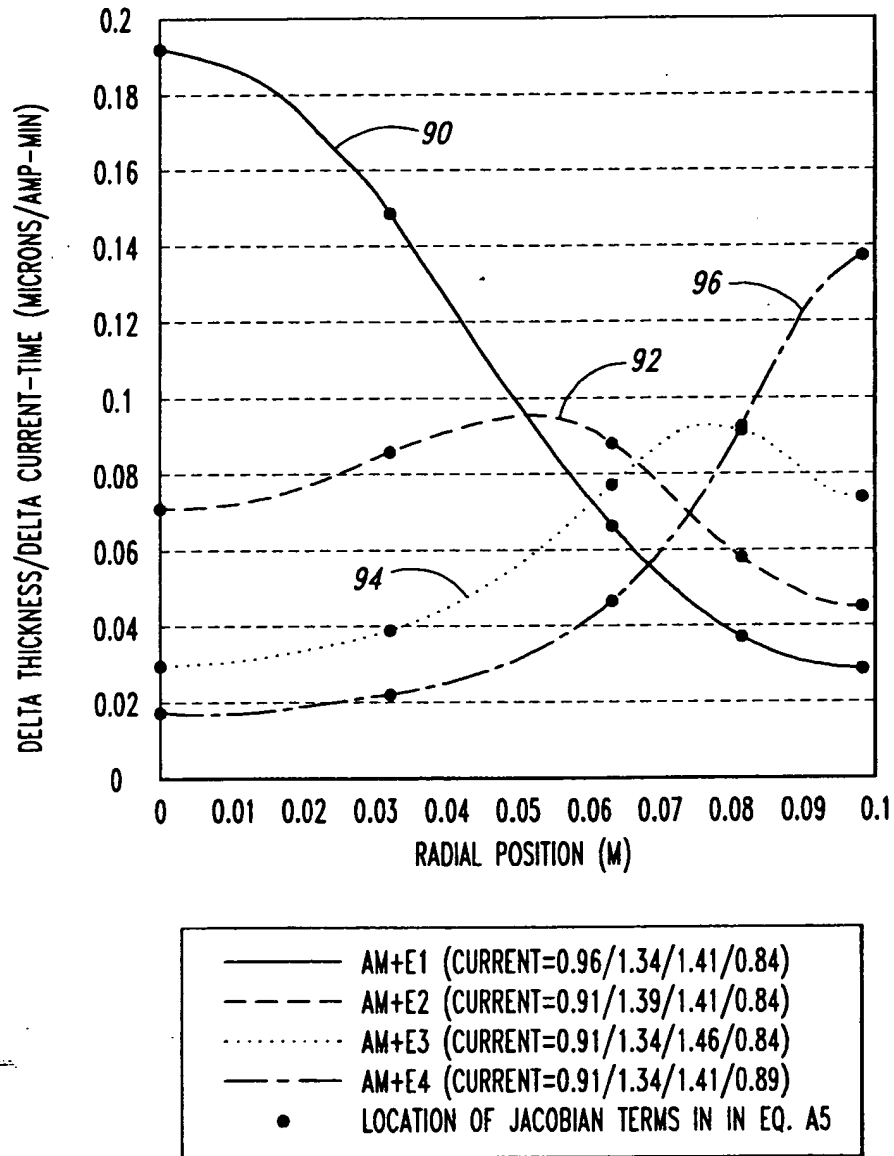


Fig. 5

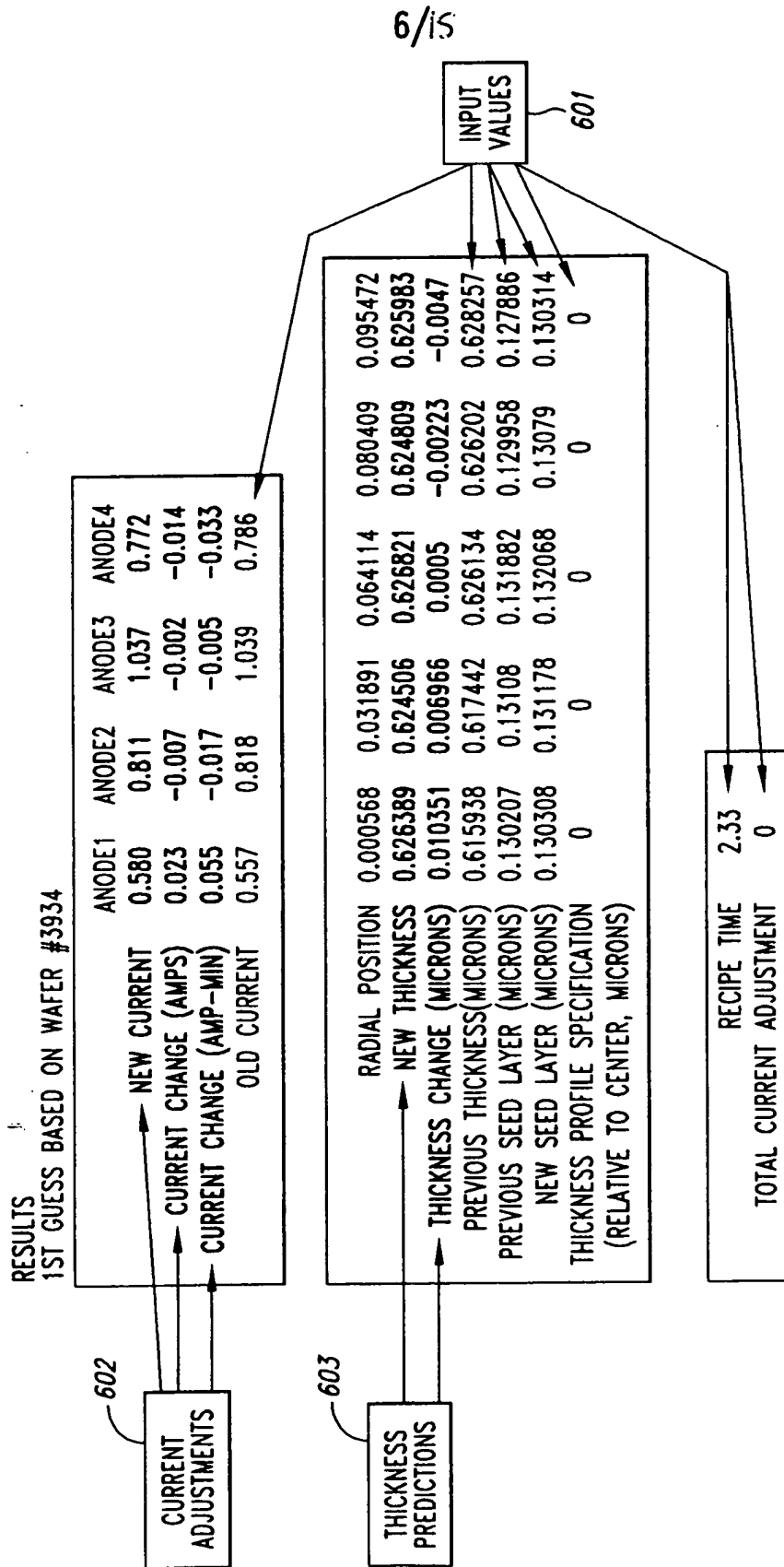


Fig. 6

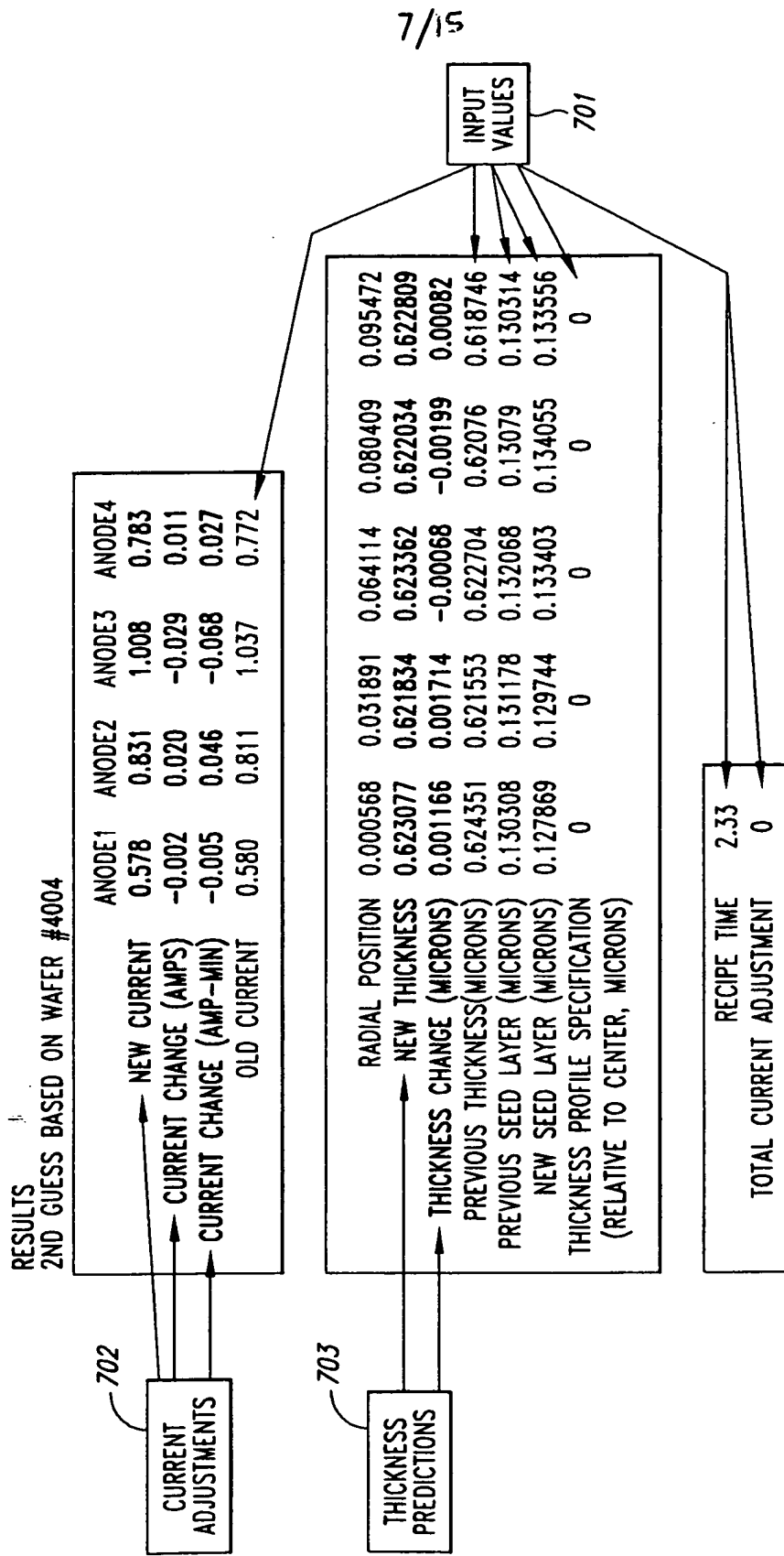


Fig. 7

FIGURE 3

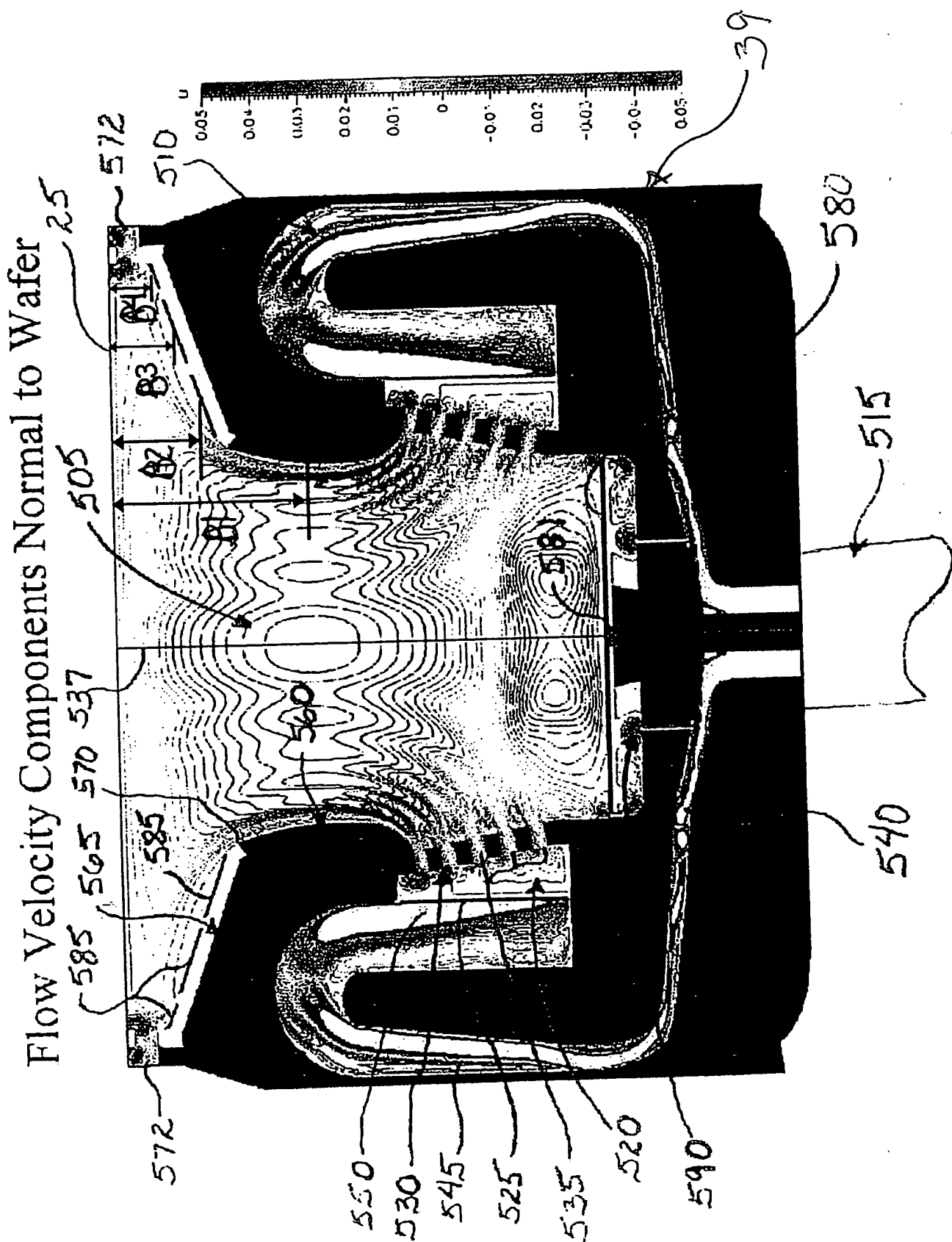
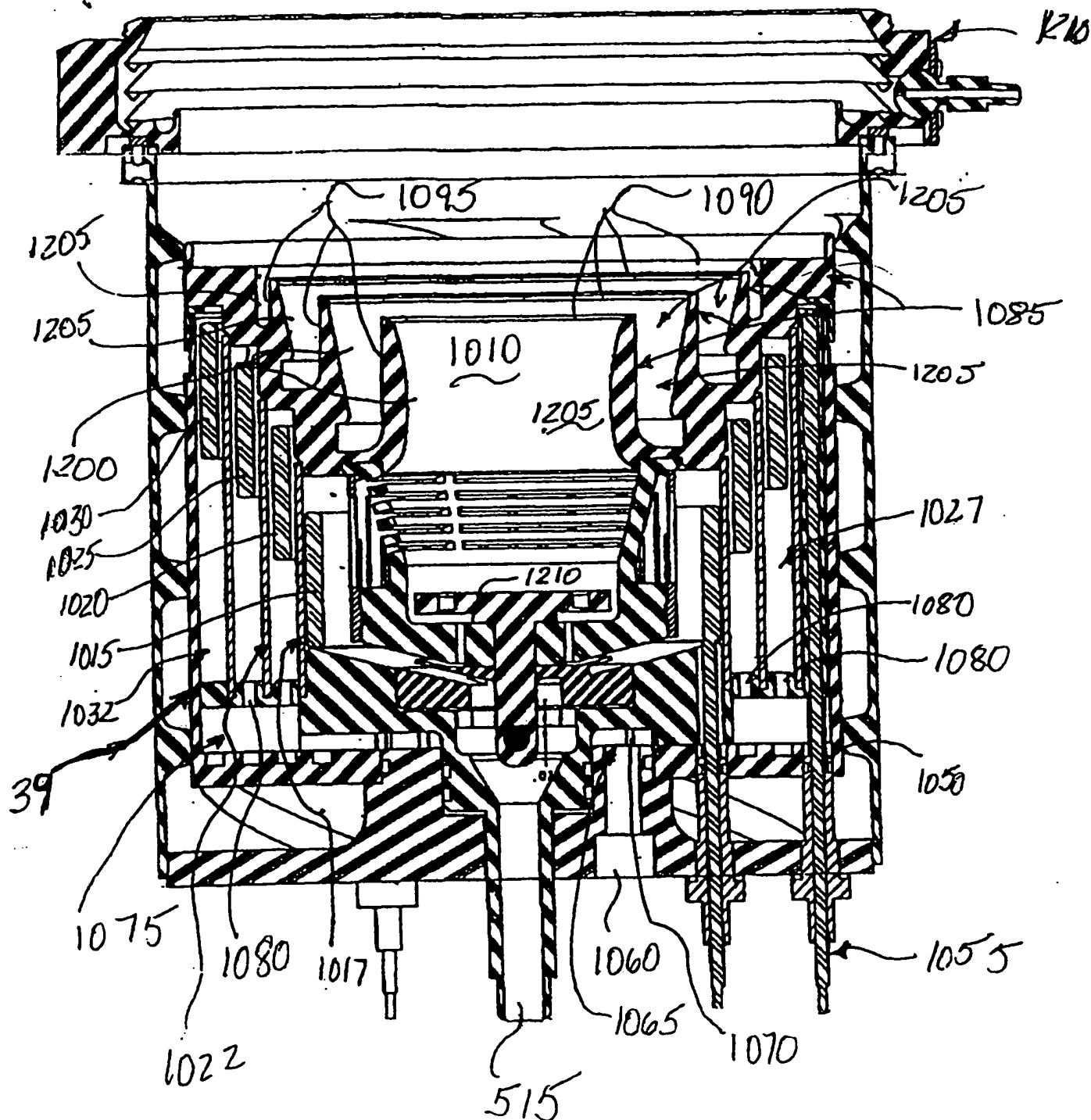




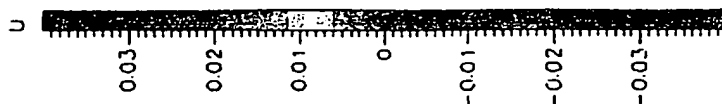
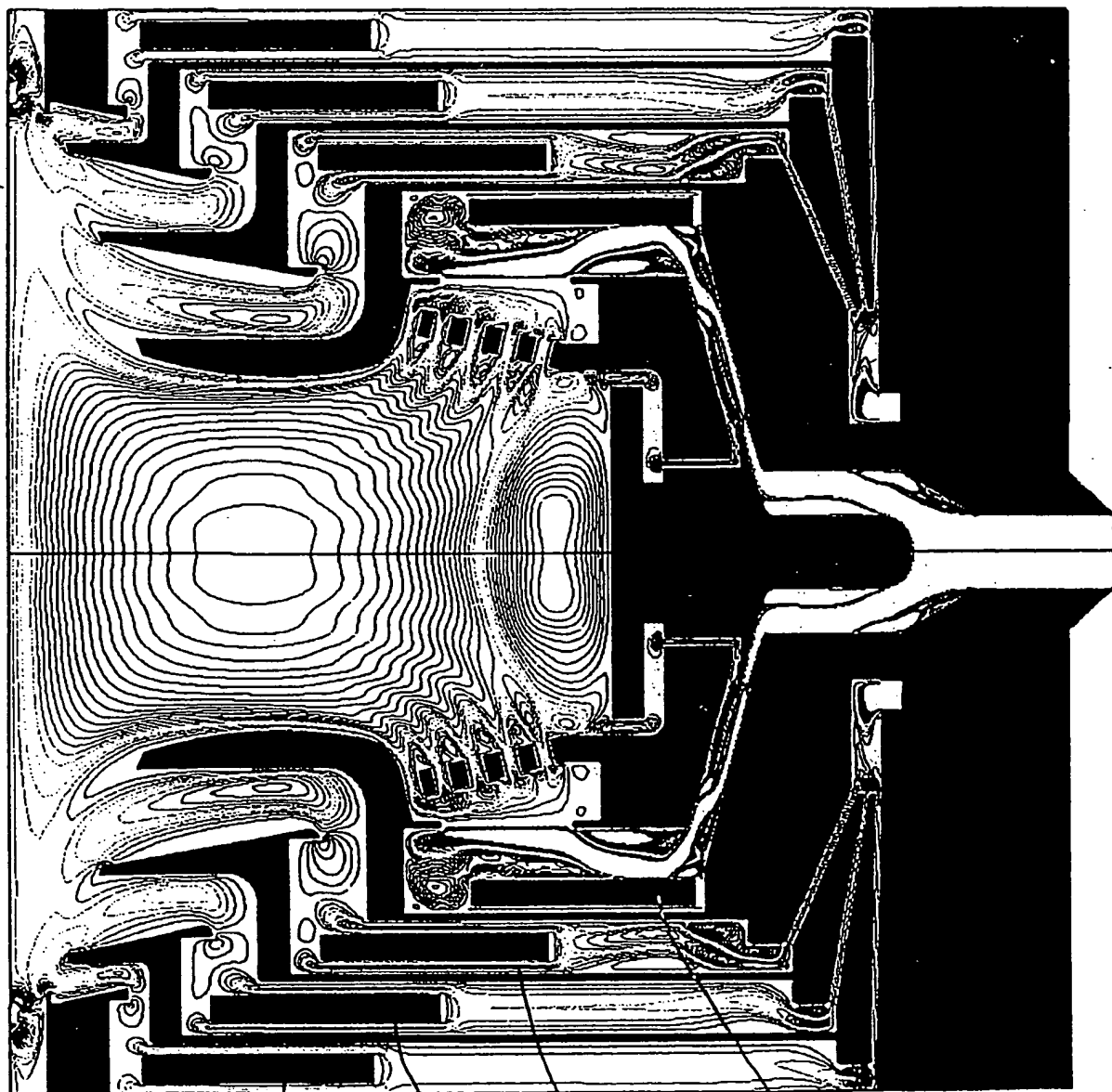
FIGURE 9





# Workpiece Normal Velocity Contours Two Flow Paths Refreshing Anodes

(Scale -0.05 to 0.05 m/sec)



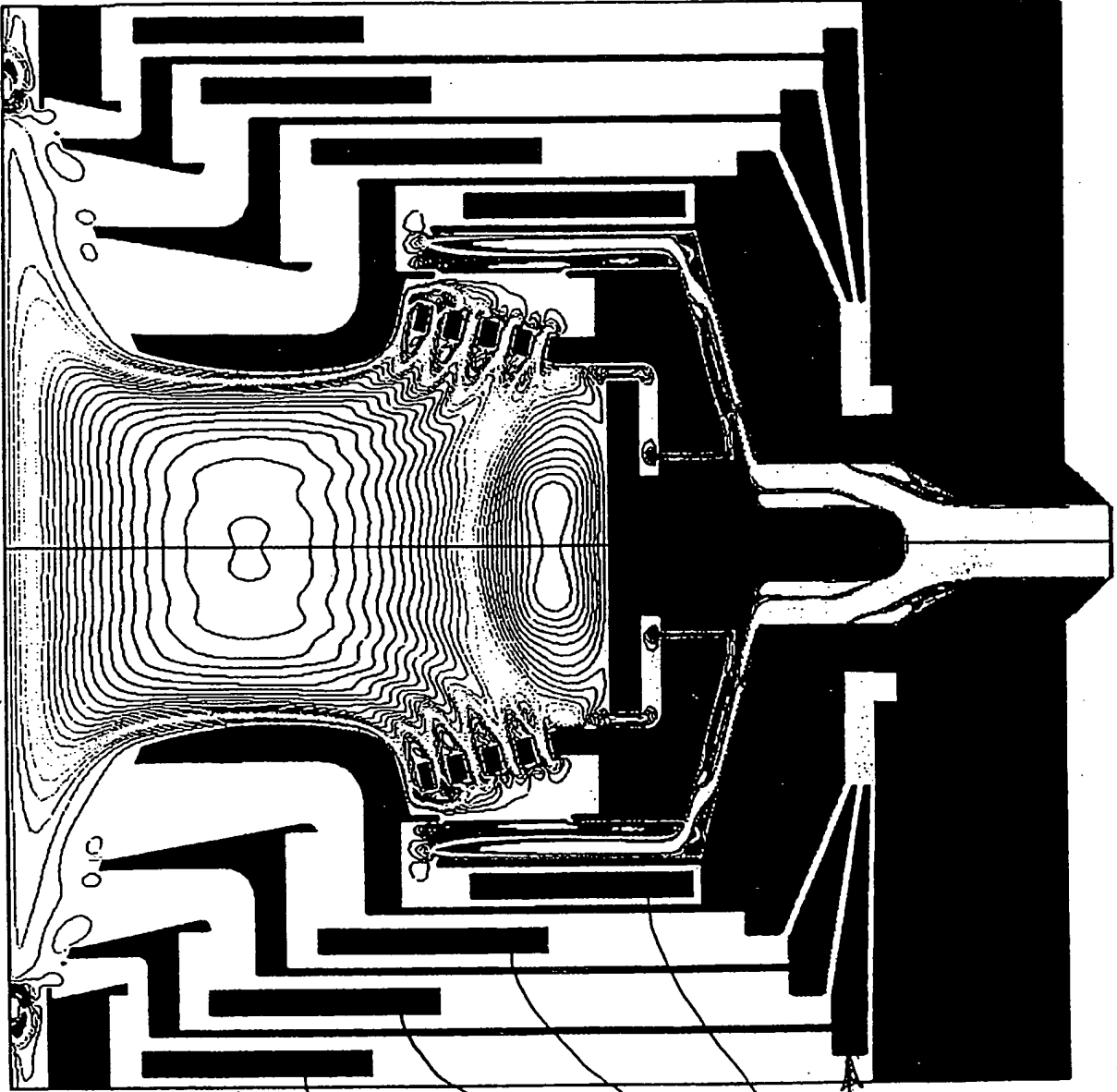
39  
1030  
1025  
1020  
1015  
2010

FIGURE 11

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# Workpiece-Normal Velocity Contours Single Flow Path (No Flow Over Anodes)

(Scale -0.05 to 0.05 m/sec)



39

1030

1025

1020

1015

2010

FIGURE 12

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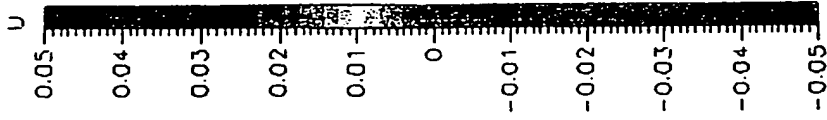
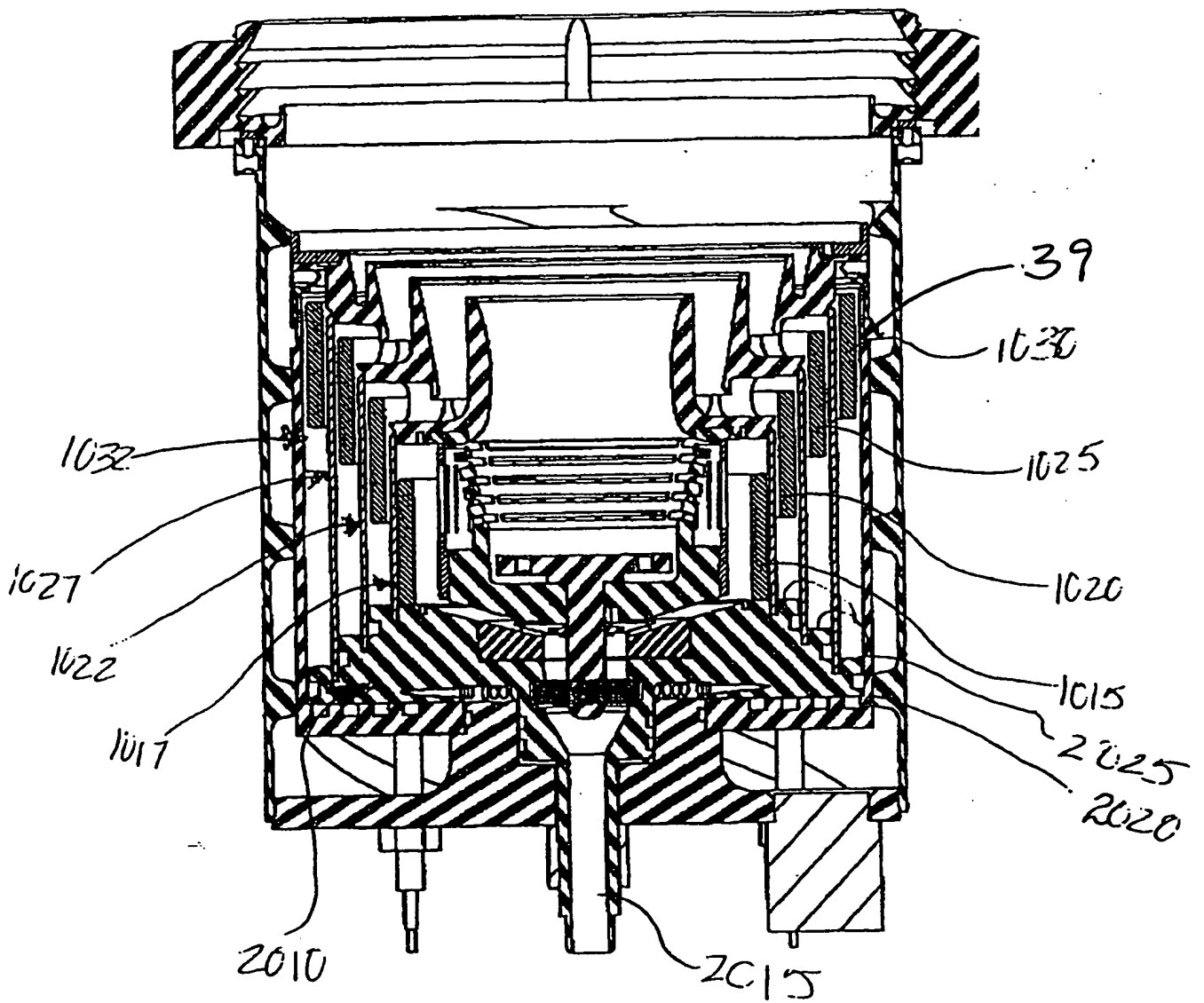


FIGURE 13



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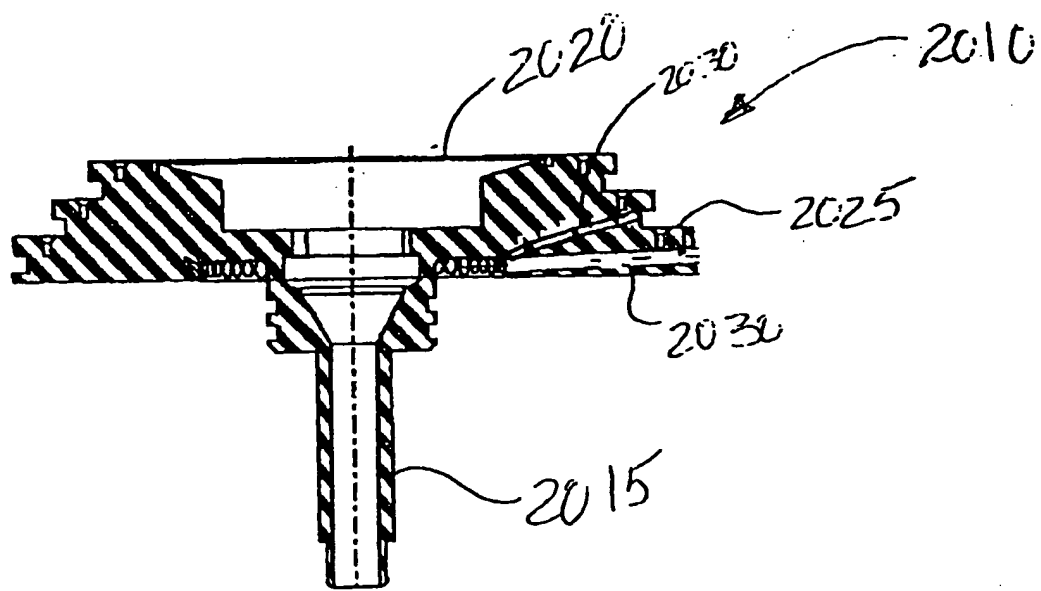


FIGURE 14

FIG. 15

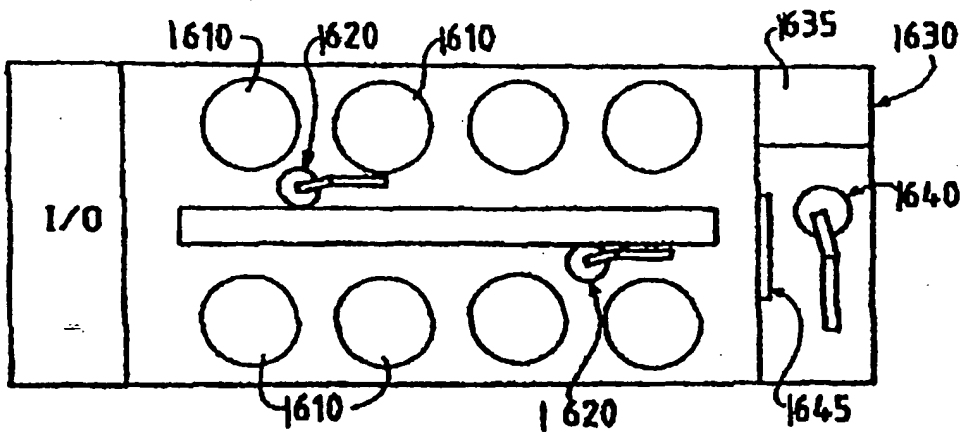
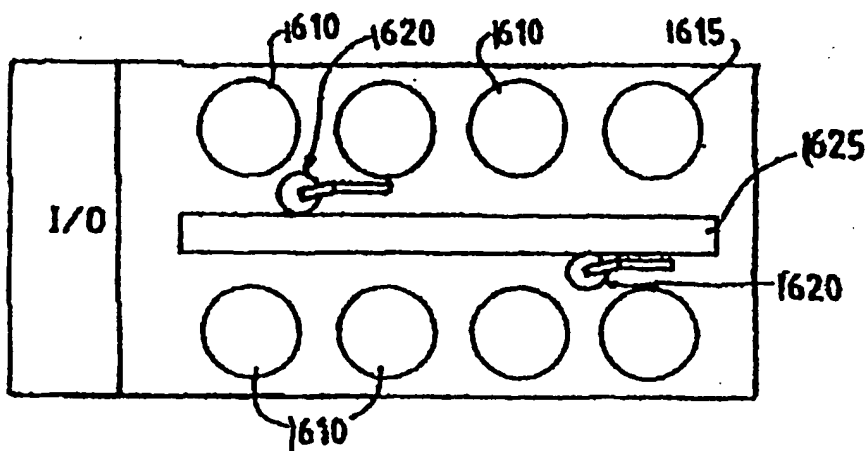


FIG. 16